

Work Order ID 86762-2

July-06-12 2:19:19 PM

\*86762\*

DRAB GREEN

Page 1

Item ID: D3405-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug Assembly

Start Date: 7/06/12 Start Qty: 30.00 \*30\*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 30.00 \*30\*

Customer:

Reference:

Approvals: Process Plan: Date: 7-07-12

Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

30 0 Jm 12-7-12

30 0 Jm 12-7-12

6 8.26.12

WTS  
30



# Work Order ID 86762

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**\*86762\***

Page 2

Item ID: D3405-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lug Assembly

Start Date: 7/06/12

Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

**\*130\***

Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr

2-Form using DT8204 as per Dwg D3405

3- use DT9681 to check if correct forming

0.00

0.00

19

12/07/25

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DA 12/6/26

19

150

**\*150\***

Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-041

0.00

0.00

19

12-8-14

# Work Order ID 86762

**\*86762\***

Page 3

July-06-12 2:19:19 PM

Item ID: D3405-041      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Lug Assembly  
Start Date: 7/06/12      Start Qty: 30.00      **\*30\***      Cust Item ID:  
Required Date: 8/10/12      Req'd Qty: 30.00      **\*30\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
<b>*180*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

DAS 10 12.08.14 19

SMB 12-8-14 DAS 16 12/08/14

DRAB GREEN MF

12-08-17 8X6

mf 12/08/20

START TIME: 8:15  
OVEN TEMPERATURE: 3200 F  
FINISH TIME: 8:45

m164476

# Work Order ID 86762

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**\*86762\***

Page 4

Item ID: D3405-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lug Assembly

Start Date: 7/06/12 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center

Operation  
Description

Set Up  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*8x 1 12/08/20*

200

Identify as per dwg & Stock Location: *523*

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

*51 8 12/08/20*

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

*MUJ 12 108123*

*ME 12-08-22*

# Picklist Print

July-06-12 2:19:19 PM

Page 1

Work Order ID: 86762  
 Parent Item: D3405-041  
 Parent Item Name: Lug Assembly

Start Date: 7/06/12  
 Start Qty: 30.00  
 Required Date: 8/10/12  
 Required Qty: 30.00

Comments: IPP A05.09.01New issueKJ/JLM  
 IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1 GHW Lug		Manufactured	No			100	Each	126.0000	1	30			
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						WA		126					
						83879		26					
						85100		100					
M304S11GA 304/316 0.125 Sheet		Purchased	No			150	sf	45.0260	0.154	4.863159			
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						MAT020		45.026					
						121380		23.9					
						121780		21.126					

85451x3

12-8-14

16

5.0

121380

Jm 12-7-1



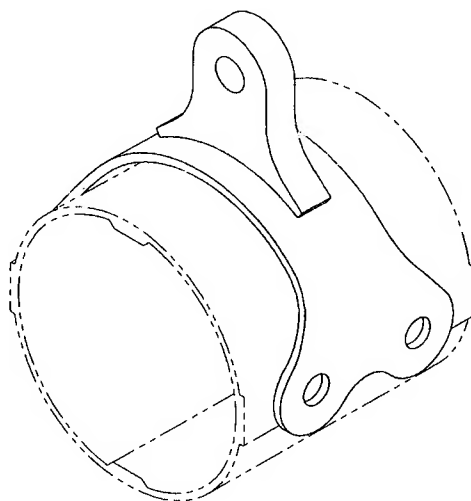




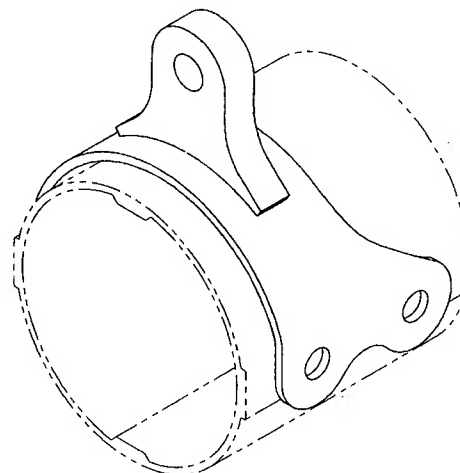
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86762 2012-079



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)





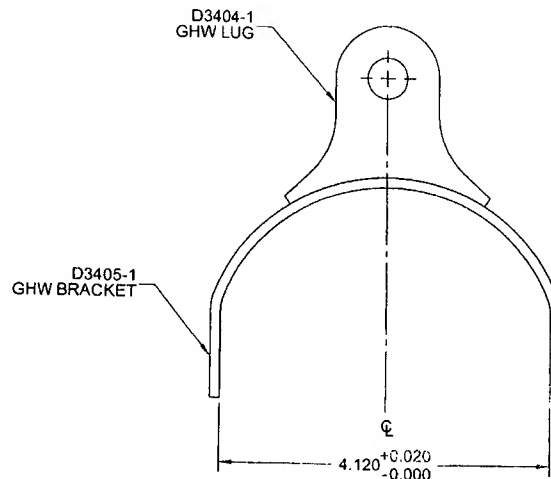
**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

**RELEASED**  
08/12/18 MP

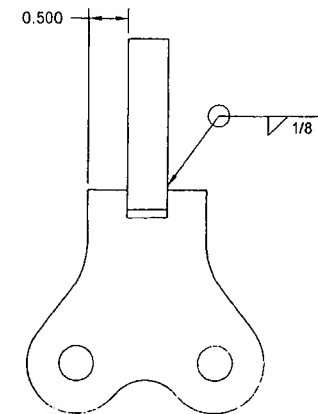
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

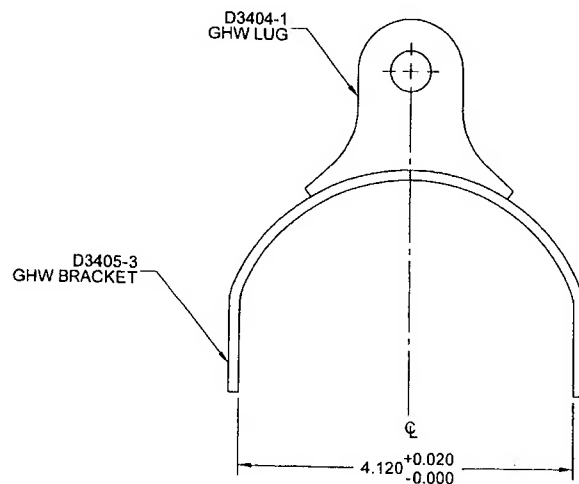
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.			AJS	08.09.19
A	NEW ISSUE			PH	05.03.08
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b>			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV.		
MFG. APPR.		D3405	SHEET 1 OF 4		
APPROVED		TITLE	SCALE		
DE APPR.		GHW LUG ASSEMBLY	NTS		
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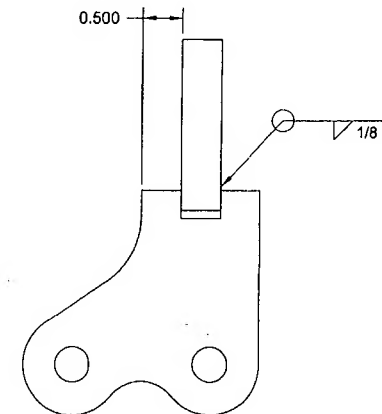
**D3405-041 LUG ASSEMBLY**



86762

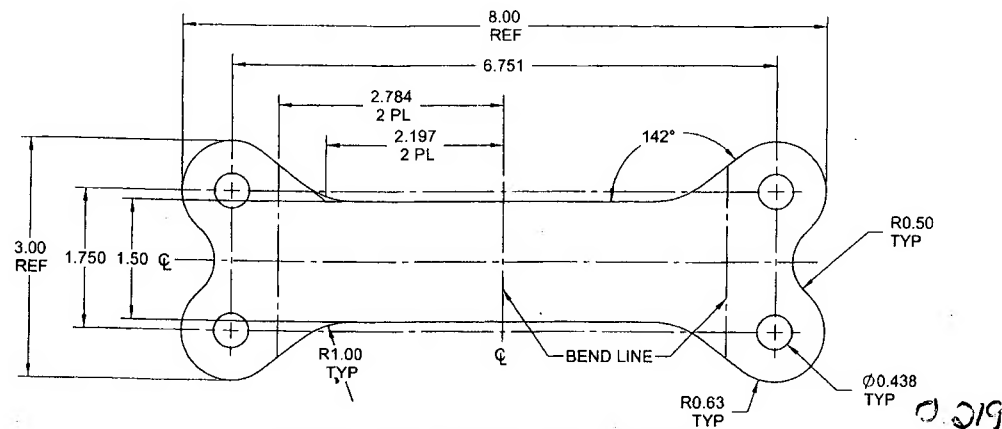


**D3405-043 LUG ASSEMBLY**

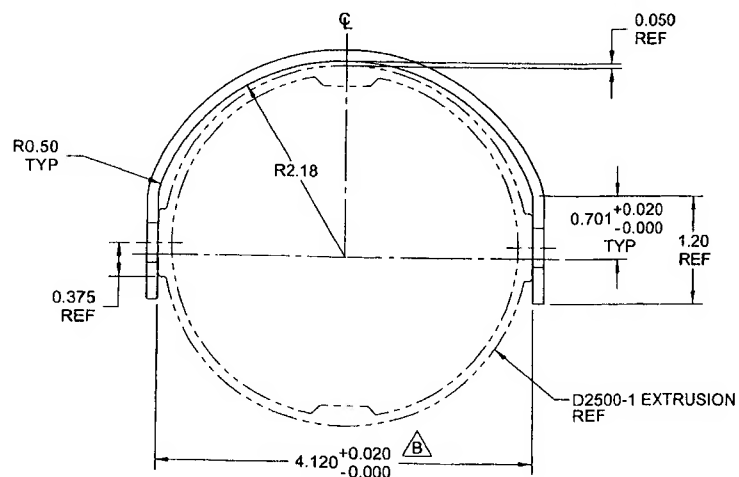


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06/12/18 MTP

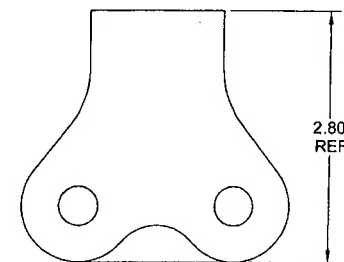
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



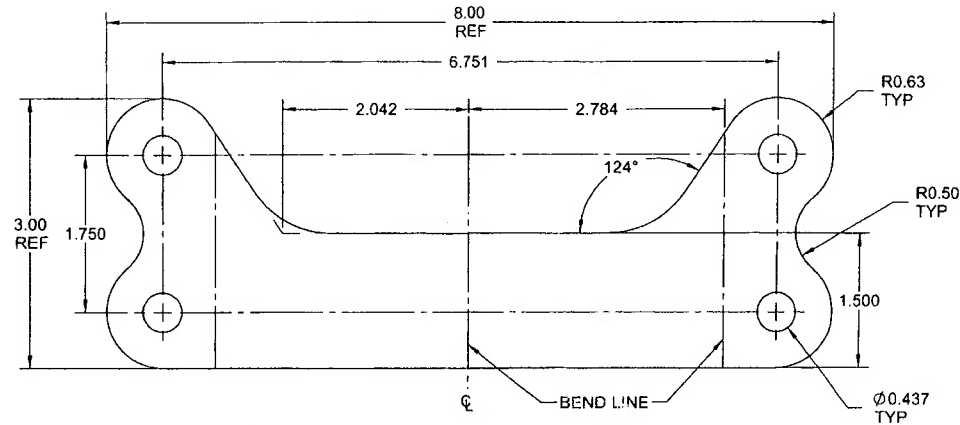
SIDE VIEW FOR REF ONLY

**NOTES:**

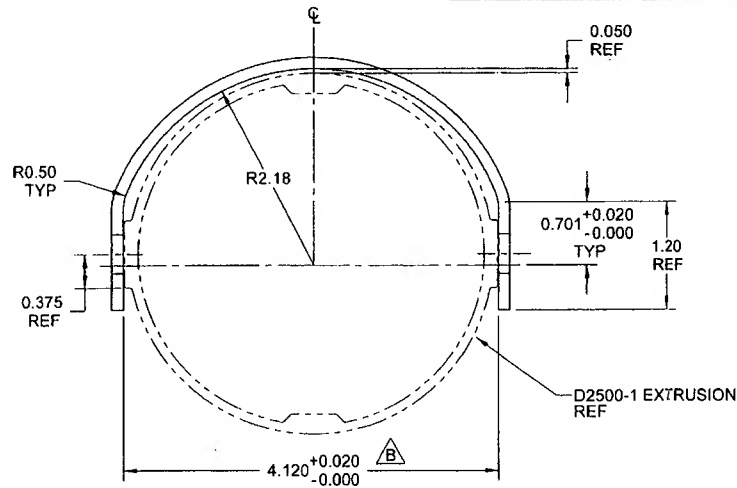
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
11/18/11

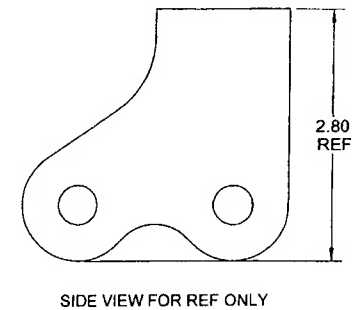
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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**D3405-3F GHW BRACKET FLAT PATTERN**



**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO. <b>D3405</b>	REV. B SHEET 4 OF 4
MFG. APPR.		TITLE <b>GHW LUG ASSEMBLY</b>	SCALE NTS
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